

Work Order ID 80027

Thursday, February 09, 2012 9:03:59 AM

80027

Page 1

Item ID: D3999-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Baffle Assembly, Aft

Start Date: 2/10/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-02-09*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3999

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3999-1

*6061 .062*Dwg Rev: *A*
Prog Rev: *A*

2-Deburr if necessary

*B 12-2-9**(4)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B 12-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Baffle Assembly, Aft

Stop ***NS2***

Start Date: 2/10/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend D3999-1 as per Dwg

180

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

5/2/02/01

(4)

SB 12/03/07

(4)

SB 12/03/08 (4)

Dart Aerospace Ltd

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Page 3

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Baffle Assembly, Aft

Stop ***NS2***

Start Date: 2/10/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

5/12/13/08

44

200

Identify as per dwg & Stock Location: UA

0.00

200

Packaging

Memo

0.00

Packaging

12.03.08

4

φ

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/3/8

12.03.8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, February 09, 2012 9:03:59 AM

Page 1

Work Order ID: 80027

Parent Item: D3999-041

Parent Item Name: Baffle Assembly, Aft

Start Date: 2/10/2012

Required Date: 2/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B 10.05.10 ecn 10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	273.0696	2.27	9.5578947			

B12-2-9

(4)

Location	Loc Qty	Loc Code
MAT021	273.0695684	
113608	0	
116308	11.4555684	
117285	75.414	
119331	49.2	
119802	25.5	
120218	111.5	

D3999-5 Angle	Manufactured	No				180	Each	2.0000	2				
------------------	--------------	----	--	--	--	-----	------	--------	---	--	--	--	--

Location	Loc Qty	Loc Code
ST104	2	
71295	1	
72654	1	

MS20470AD4-4 Rivet, Universal Head	Purchased	No				180	Each	6,598.0000	12	48			
---------------------------------------	-----------	----	--	--	--	-----	------	------------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST319	6598	
116188	136	
116391	66	
118614	1190	
119109	348	
120361	1858	
120518	3000	

120278
8/5/12/03/08
B80039
72
8/5/12/03/08

4/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

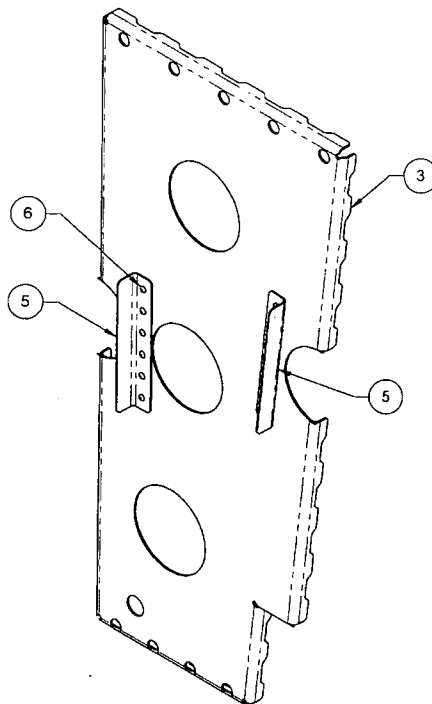
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

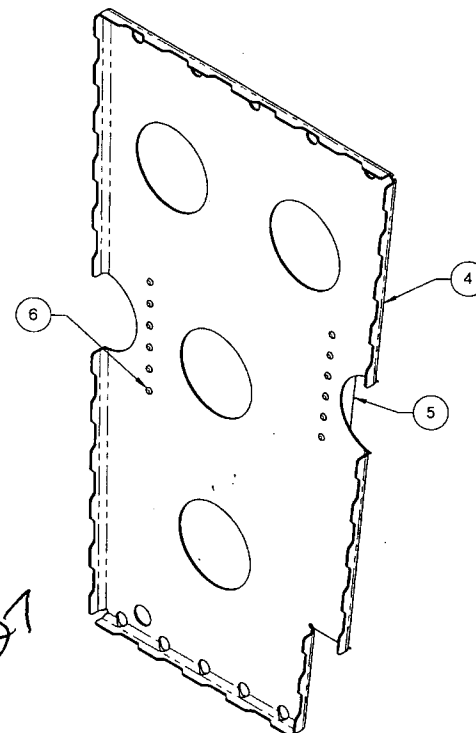
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X		D3999-041	BAFFLE ASSEMBLY, AFT	JCA-M47-1-02
2		X	D3999-043	BAFFLE ASSEMBLY, FWD	JCA-M47-1-03
3	1		D3999-1	BAFFLE	
4		1	D3999-3	BAFFLE	
5	2	2	D3999-5	ANGLE	
6	12	12	MS20470AD4	RIVET	



D3999-041 BAFFLE ASSEMBLY, AFT



D3999-043 BAFFLE ASSEMBLY, FWD

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3999-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT (-041): 1.51 lbs
- 8) WEIGHT (-043): 1.84 lbs

A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION		
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3999	REV. A
TITLE BAFFLE	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

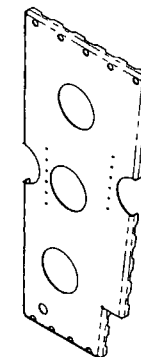
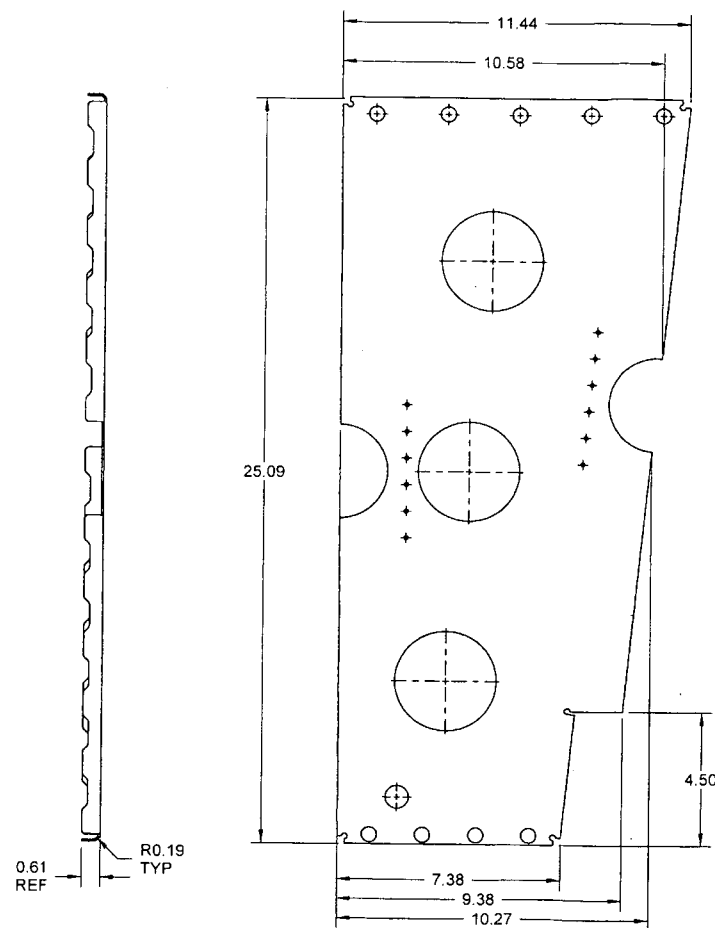
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-1	REF JCA-M47-1-02



D3999-1 BAFFLE

NOTES:

- 1) MATERIAL: MADE FROM D3999-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.44 lbs

RELEASED
2010-05-05
MP

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3999	REV. A
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DE APPR.			NTS
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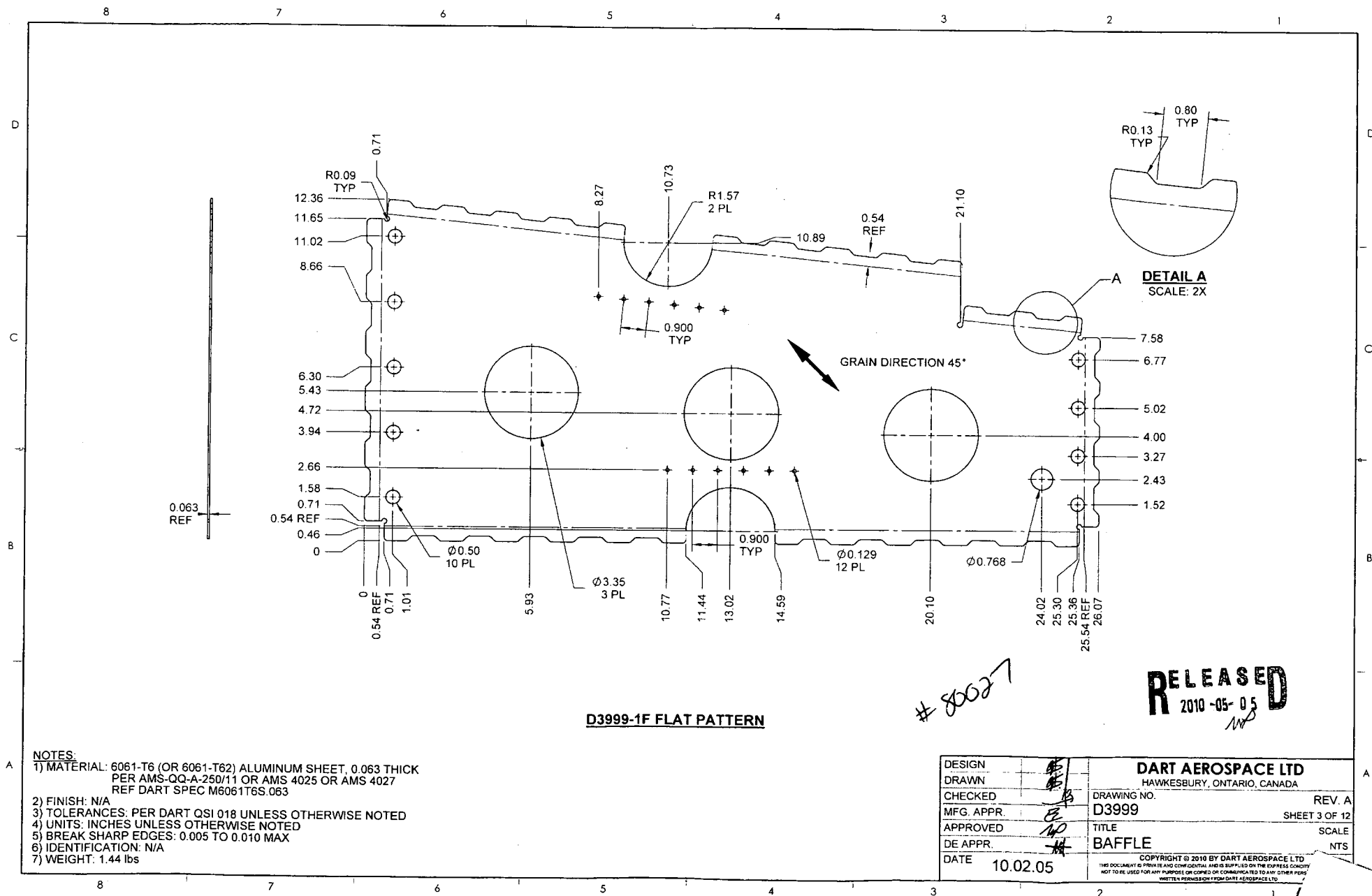
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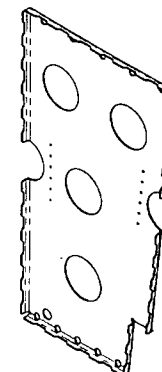
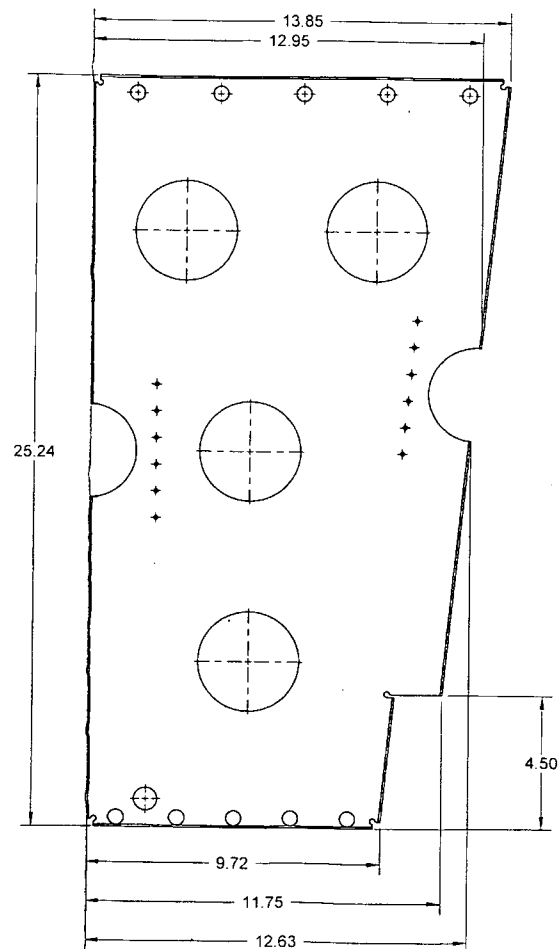
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-3	REF JCA-M47-1-03

R0.19
TYP

0.61
TYP



80027

RELEASED
2010-05-03
MS

D3999-3 BAFFLE

NOTES:

- 1) MATERIAL: MADE FROM D3999-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.77 lbs

DESIGN	DATE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	10.02.05	DRAWING NO.	REV. A
CHECKED		D3999	SHEET 4 OF 12
MFG. APPR.		TITLE	SCALE
APPROVED		BAFFLE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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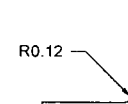
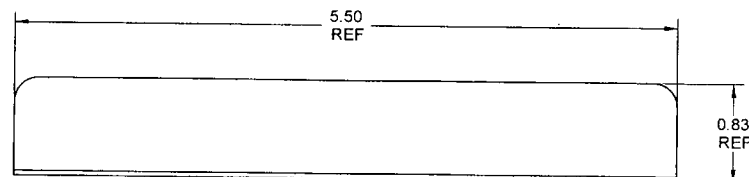
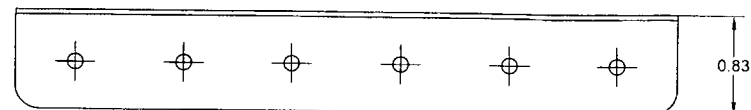
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-5	REF JCA-M47-1-02 REF JCA-M47-1-03



#80027

D3999-5 ANGLE

RELEASED
2010-05-05
MD

NOTES:

- 1) MATERIAL: MADE FROM D3999-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3999	SHEET 6 OF 12
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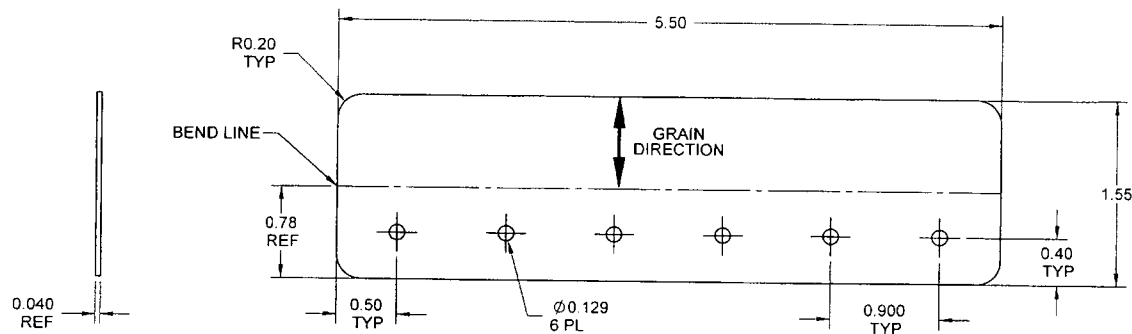
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D3999-5F FLAT PATTERN

RELEASED
2010-05-05
JWP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3999	SHEET 7 OF 12
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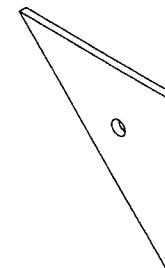
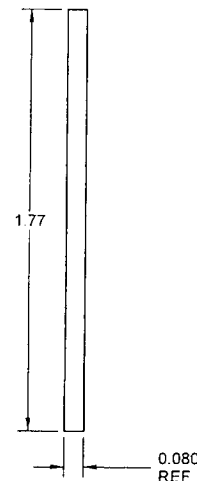
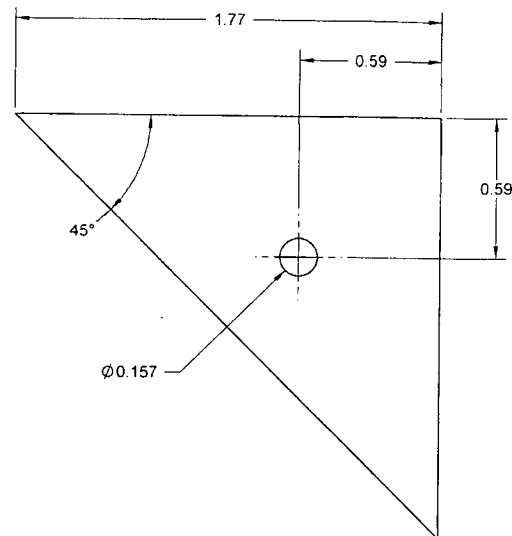
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-7	JCA-M47-1-17



80027

D3999-7 CORNER

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3999	SHEET 8 OF 12
APPROVED		TITLE	SCALE
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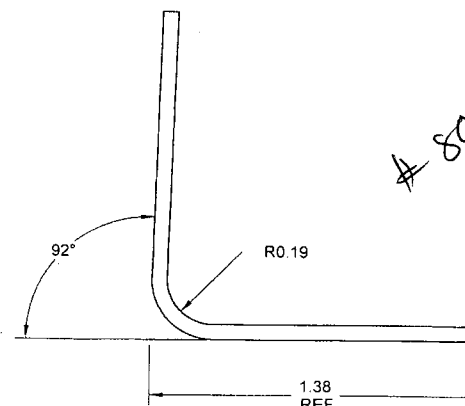
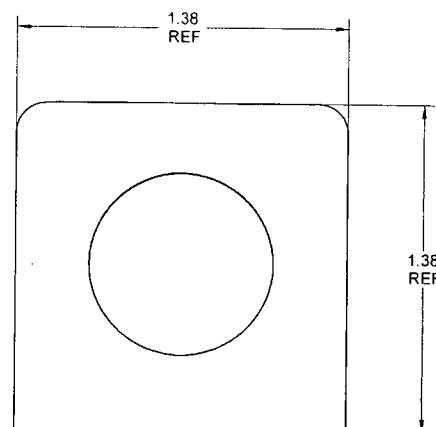
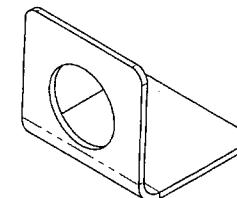
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D3999-9

JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-1-18



#80027

D3999-9 ANGLE

RELEASED
2010-05-05
11/10

NOTES:

- 1) MATERIAL: MADE FROM D3999-9F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3999
MFG. APPR.		REV. A
APPROVED		SHEET 9 OF 12
DE APPR.		SCALE
DATE	10.02.05	TITLE BAFFLE
		NTS

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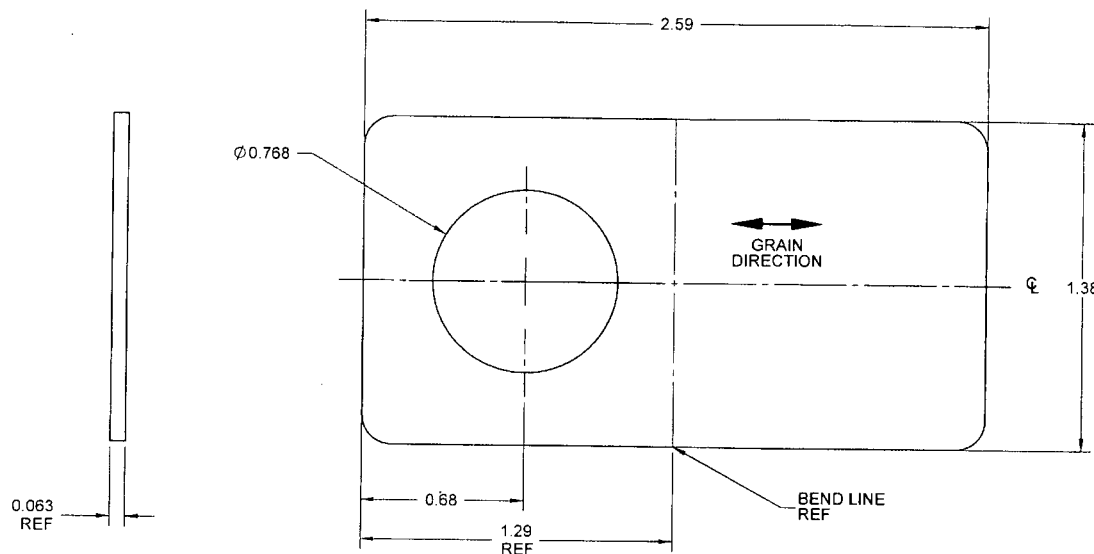
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



80027

D3999-9F FLAT PATTERN

RELEASED
2010-05-05
MP

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S0.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3999	SHEET 10 OF 12
APPROVED		TITLE	SCALE
DE APPR.		BAFFLE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

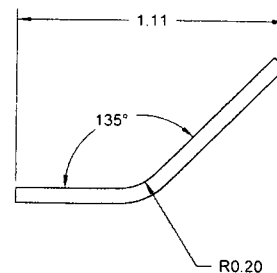
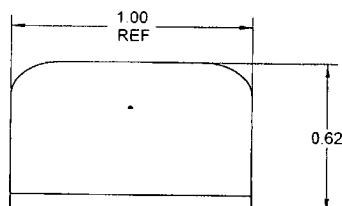
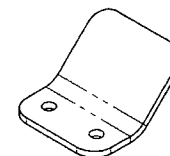
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19



80027

D3999-11 EARTH TAB

RELEASED
2010-05-05
NW

NOTES:

- 1) MATERIAL: MADE FROM D3999-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3999	REV. A
MFG. APPR.			SHEET 11 OF 12
APPROVED		TITLE BAFFLE	SCALE NTS
DE APPR.			
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

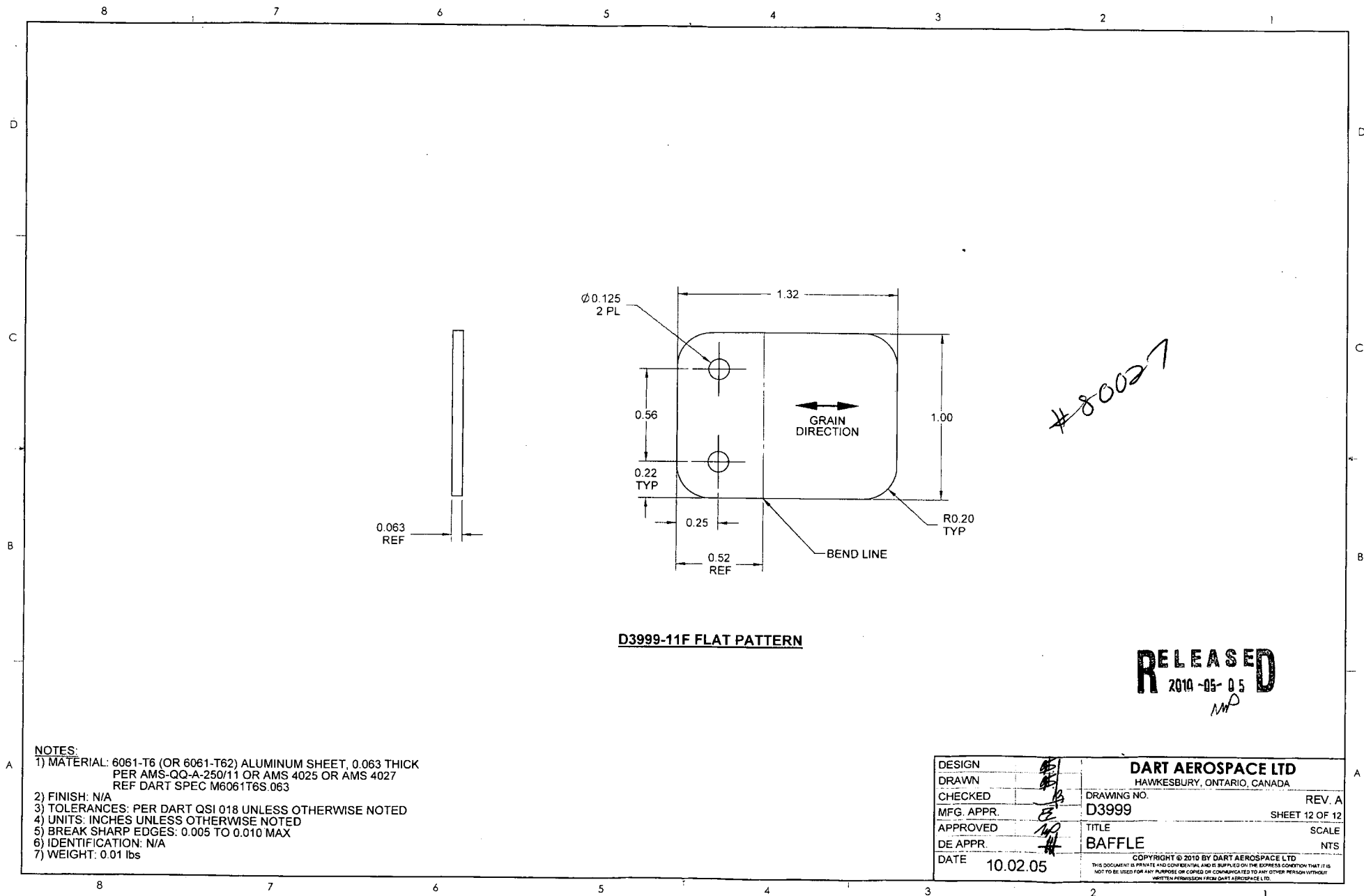
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80027
Description: Baffle		Part Number:	D3999-1
Inspection Dwg: D3999 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.134	2		V RB02	
Ø0.50	+0.006/-0.001	.506	2		V	
Ø3.35	+0.012/-0.001	3.351	2		V	
0.71	+/-0.030	.706	2		V	
1.01	+/-0.030	1.013	2		V	
5.93	+/-0.030	5.932	2		V	
10.77	+/-0.030	10.774	2		T RB01	
11.44	+/-0.030	11.443	2		T	
0.900	+/-0.010	.901	2		V	
13.02	+/-0.030	13.02	2		T	
14.59	+/-0.030	14.59	2		T	
20.10	+/-0.030	20.10	2		T	
24.02	+/-0.030	24.02	2		T	
25.30	+/-0.030	25.30	2		T	
25.36	+/-0.030	25.36	2		T	
26.07	+/-0.030	26.07	2		T	
1.52	+/-0.030	1.524	2		V	
2.43	+/-0.030	2.433	2		V	
3.27	+/-0.030	3.271	2		V	
4.00	+/-0.030	4.003	2		V	
5.02	+/-0.030	5.021	2		V	
6.77	+/-0.030	6.773	2		V	
7.58	+/-0.030	7.586	2		V	
0.71	+/-0.030	.711	2		V	
8.27	+/-0.030	8.27	2		T	
10.73	+/-0.030	10.73	2		T	
21.10	+/-0.030	21.10	2		T	
0.71	+/-0.030	.711	4		V	
1.58	+/-0.030	1.582	2		V	
2.66	+/-0.030	2.661	2		V	
3.94	+/-0.030	3.943	2		V	
4.72	+/-0.030	4.722	2		V	
5.43	+/-0.030	5.43	2		V	
6.30	+/-0.030	6.30	2		V	
8.66	+/-0.030	8.66	2		V	
11.02	+/-0.030	11.02	2		T	
11.65	+/-0.030	11.65	2		T	

DART AEROSPACE LTD		Work Order:	80027
Description: Baffle		Part Number:	D3999-1
Inspection Dwg: D3999 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.36	+/-0.030	12.36	✓		T	
0.80	+/-0.030	.80	✓	✗	H307	
0.063	+/-0.010	.063	✓		H302	

Measured by: RB Date: 12-2-9	Audited by: S Date: 12/2/04	Preliminary Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue	KJ	[Signature]